



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3806-00
Job Sheet 194411



Part No: RBE350A93-3806-00

Job Qty: 2 pcs

Part Name: Rotating Star Replacement Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 6/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 15684*

Note: DWG RBE350A93-3806-00 Rev.1 IPP Rev. A 18.12.13 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S192026



Part: RBE350A93-3806-00

Job No: 194411

Serial No/Batch: S192026

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 06/19/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	6/17/19		0.00	0.40	Small Fab - 1		
							Small Fab - 2		MU
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	6/17/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		DAS
							QC 5 - 40		40
120	Packaging 3-1 - Stock - B4B	2 pcs	6/17/19		0.00	0.00	Packaging 3 - 1 - B4B		9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS
							Packaging 3 - 6 - B4B		28
							Packaging 3 - 7 - B4B		9-89
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	2 pcs	6/17/19		0.00	0.00	QC 21 - FG - 21		
							QC 21 - FG - 70		DAS
							QC 21 - SA - 53		21

Part Op
Descriptions: 100 - Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A93-3806-00-1	Socket	2 pcs (1 ea)	100-Small Fab - 1	5187843
RBE350A93-3806-00-3	Pin	2 pcs (1 ea)	100-Small Fab - 1	5186330

Job Allocations

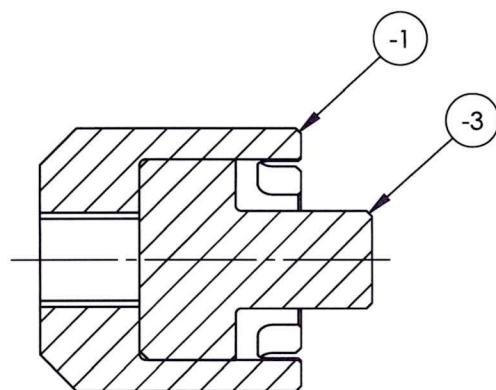
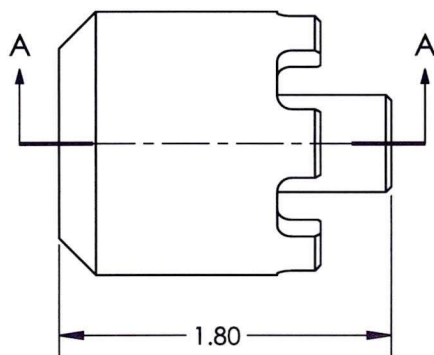
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBE350A93-3806-00-1	2	0	0
	RBE350A93-3806-00-3	2	0	0

Part Specifications
Specifications could not be found.

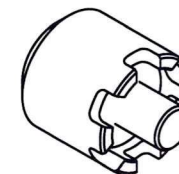
Plex 5/2/19 7:36 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 MOVE TO SEPARATE SHEET, ADDED DIM. R.035 MAX., CH'D DIM WAS .500 +.005-.000 IS LIMITS .503 TO .508, WAS Ø1.083 P.F. -3 IS LIMITS Ø1.0830 TO 1.0838, CH'D NOTE WAS ENGRAVE T/N, S/N, & MADE IN USA TO FIT IS ENGRAVE T/N, S/N, MADE IN USA -3 MOVED TO SEPARATE SHEET, CH'D DIM. WAS Ø1.083 P.F. -1 IS LIMITS Ø1.0844 TO 1.0849.	2/11/14	DPD	RJC
1	15-0111	CH'D TOOL NAME WAS WRENCH ROTATING STAR REPLACEMENT IS WRENCH M27. ADDED DIM 1.80 TO ASSEMBLED TOOL. -1 CH'D DIM WAS .787 IS .88, ADDED 12X R.08. -3 CH'D MATERIAL WAS 6061 IS 4140/4142 Q&T, CH'D FINISH WAS CLEAR ANODIZE IS YELLOW ZINC, CH'D DESCRIPTION WAS CENTER IS PIN, CH'D CHAMFER WAS .09 X 45° IS .05 X 45°, CH'D DIM WAS .714 IS .740, WAS 1.189 IS 1.26, WAS Ø.527 +.000-.002 IS Ø.525.	5/16/15	RJC	JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194411 MJS
190502

NOTE:

1. REF. EUROCOPTER T/N: 350A93-3806-00.
2. NSN: 5120-14-401-5637.

DART AEROSPACE	
TITLE WRENCH M27	
DWG NO. RBE350A93-3806-00	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>J. Gilbert</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL AS350	
SCALE 1:1	DATE 3/12/2015
SHEET 1 OF 3	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	SOCKET	4140 Q&T / 4142 Q&T		2
			-3	1	PIN	4140 Q&T / 4142 Q&T		3

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					